

Work Order ID 130659 -1

Thursday, March 19, 2015 10:49:47 AM

350-615-041
B130659
REV: B

130659

Page 1

Item ID: D350-615-041

Revision ID:

Item Name: GHW Modification, Fits LH or RH

Start Date: 3/19/2015 Start Qty: 18.00

Required Date: 3/19/2015 Req'd Qty: 18.00

Reference:

Approvals: Process Plan: MS

QC:

Date: 1503-19

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D350-615-041

B

100

Document Control

0.00

100

DC

Doc. Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003

APR 02 2015

DAS
28
9-89

110

110

Small Fab

Small Fab

Memo

0.00

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C bolts***

DAS
28
9-89

MAR 23 2015

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
38
9-89

MAR 30 2015

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Page 2

Item ID: D350-615-041

Revision ID:

Item Name: GHW Modification, Fits LH or RH

Start Date: 3/19/2015 Start Qty: 18.00

Required Date: 3/19/2015 Req'd Qty: 18.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

18

18

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC4- 100% Inspect kits for completeness

0.00

130

QC

Quality Control

Memo

0.00

APR 02 2015

6

DAS
86
9-89

140

140

Packaging

Packaging

Memo

0.00

Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041

Location:

PPP Rev:

APR 02 2015

f6023

6

DAS
86
9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Quality Control

Memo

0.00

MCS

1504-02

ME

15-4-2

Picklist Print

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Page 1

Work Order ID: 130659

130659

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 3/19/2015

Required Date: 3/19/2015

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2282-041		Manufactured	No			110	Each	18.0000	1	18			
D2282-041 T Assembly ** DAS 28 9-89													

MAR 23 2015

Location	Loc Qty	Loc Code
----------	---------	----------

GA	18	
129427	18	

D2282-043		Manufactured	No			110	Each	4.0000	1	18			
D2282-043 Saddle Assembly ** DAS 28 9-89													

Location	Loc Qty	Loc Code
----------	---------	----------

GA	4	
110847	4	

5/16-18-015C		Purchased	No			110	Each	70.0000	3	54			
5/16-18-015C SS Bolt 5/16-181.5"K ** DAS 28 9-89													

Location	Loc Qty	Loc Code
----------	---------	----------

st572	70	
M127961	70	

130708X11

18

110681X14
129428X15

54

20

Picklist Print

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Work Order ID: 130659

Parent Item: D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

130659

D350-615-041

Start Date: 3/19/2015

Required Date: 3/19/2015

Start Qty: 18.00

Required Qty: 18.00

D3015-3

Manufactured No

110

Each

119.0000

3

D3015-3

Locknut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

101

129764

100

48238

1

5/16WC

Purchased

No

110

Each

206.0000

12

5/16WC

Washer

**

DAS
28
9-89

Location

Loc Qty

Loc Code

st572

206

M127961

206

7/16-14-050C

Purchased

No

110

Each

19.0000

7/16-14-050C

SS Bolt 7/16 5"K Long (92198A672)

**

DAS
28
9-89

Location

Loc Qty

Loc Code

st572

19

120146

8

m127824

11

D3015-5

Manufactured

No

110

Each

71.0000

1

D3015-5

SS Nylock Nut 7/16

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST015

71

99599

71

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Shop Packet Print

Page 2

MAR 23 2015

Picklist Print

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Page 3

Work Order ID: 130659

Parent Item: D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

130659

D350-615-041

Start Date: 3/19/2015

Required Date: 3/19/2015

Start Qty: 18.00

Required Qty: 18.00

7/16WC

Purchased

No

110

Each

168.0000

2

36 30 58

7/16WC

**

Washer, SS Flat 7/16

DAS

28

9-99

MAR 23 2015

Location

Loc Qty

Loc Code

st572

168

120508

168

12 7 2015

30 58

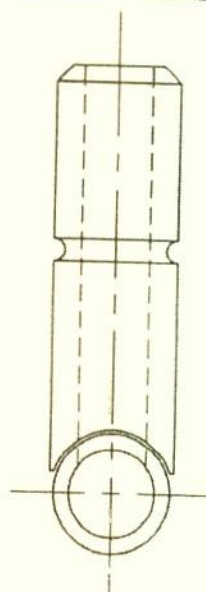
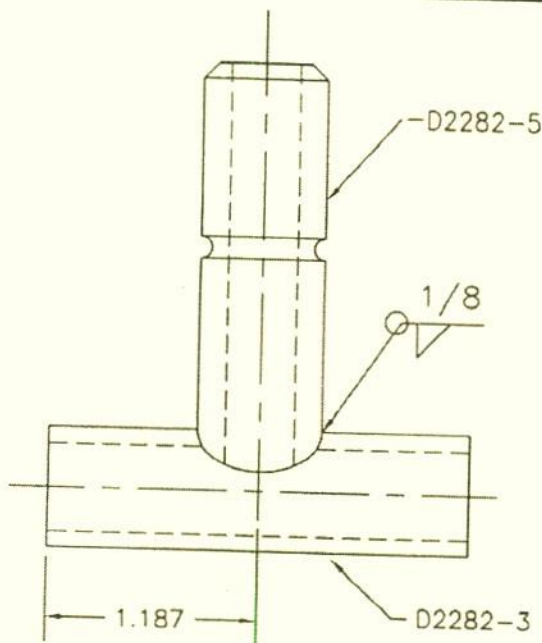
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Shop Packet Print

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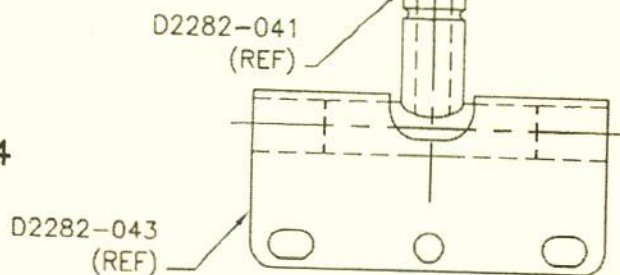


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

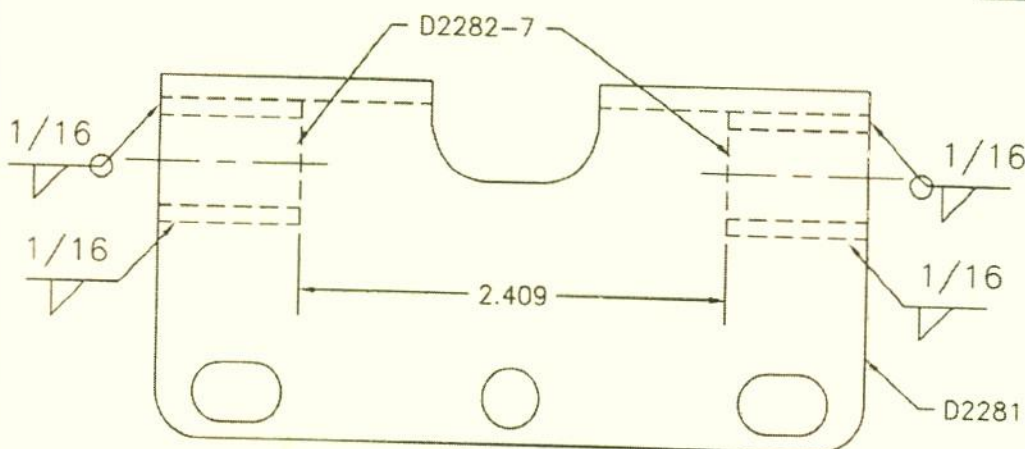


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

130659 M25
1503-19

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DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED BW	DRAWING NO. D350-615	REV. B SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

DART

DESIGN	DRWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BWS	APPROVED KE	DRAWING NO. D350-615	REV. B
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SHEET 2 OF 2
			SCALE NTS

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

EXISTING PUMP
BODY

D2282-043 SADDLE
ASSEMBLY

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)

DART SERVICE INSTRUCTION

APPLICABLE TO ALL DART AS350B3 PRODUCT

Purpose:

To confirm applicability of Dart STC product to the AS350B3e

Discussion:

Per EASA TCDS.R.008 Issue 5 dated June 17, 2011:

"The AS350B3 model a/c, which type design incorporates the following modifications:

- a) OP-4305 (Arriel2D engine installation), and additionally
- b) 07-5601 (Tail rotor control mechanism modification)
- c) 07-5600 (Tail rotor blade reinforcement)
- d) 07-8551 (Tail Gear Box control lever modification)

has a commercial designation <AS350B3e>"

Conclusion:

The AS350B3e is a commercial designation of the AS350B3 and not a new aircraft type. The changes described above do not affect the existing Dart Aerospace Ltd. product line for the AS350B3. Therefore, all Dart Aerospace Ltd products which are approved on the AS350B3 are also approved on the AS350B3e.

A	NEW ISSUE	RF	11.08.03
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9568	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AS350B3e APPLICABILITY	NTS
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130565
528-011
110-011
D4101-1
1-210120
D210120